

**Work Order ID 60963**

Friday, July 30, 2010 8:23:10 AM



Page 1

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 7/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/9/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: HDate: 10-7-30 Tooling:

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989  
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig  
3- to locate hinges and shims use D2989-041, weld as per dwg D2989  
A/R ER316 S.S. Rod Batch: 1113328

MS 10/08/17 (k)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.08.17

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Solosly

Quality Control

RD

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

ml 10 08 18 03

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel  Memo 1- Plug holes prior to powder coating  2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989  1ST COAT START TIME: 9:15 OVEN TEMPERATURE: 400 FINISH TIME: 9:45 ***** 2nd coat if necessary ***** <del>2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____</del> N/A	0.00  0.00					10	08	18 ①
140  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							10/08/18  1 0

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Friday, July 30, 2010 8:23:10 AM

Page 4

Item ID: D2989-043 Accept  Setup Start   
Revision ID: Stop   
Item Name: Basket Lid Assembly  
Start Date: 7/30/2010 Start Qty: 1.00  Cust Item ID:  
Required Date: 8/9/2010 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Packaging Packaging	Identify as per dwg & Stock Location: <i>G-A</i> <i>W/O 60961</i> Memo	0.00 0.00							<i>E 30/08/18 @</i>
160  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>10/08/19</i> <i>MF</i> <i>10-8-19</i>

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# Picklist Print

Friday, July 30, 2010 8:23:14 AM

Page 1

Work Order ID: 60963

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly




Start Date: 7/30/2010

Required Date: 8/9/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J Removed D2989-041 05-11-03 JLM  
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC  
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC  
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1  Rib		Manufactured	No			100	Each	12.0000	1	1		10/08/10	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				12					
					59275			1					
					60172			11					
D2989-3  Rib		Manufactured	No			100	Each	4.0000	1	1		10/08/10	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				4					
					59006			1					
					59034			1					
					60552			2					
D2989-4  Rib		Manufactured	No			100	Each	2.0000	1	1		10/08/10	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
					60551			2					

# Dart Aerospace Ltd

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Page 2

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Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 7/30/2010

Required Date: 8/9/2010

Start Qty: 1.00

Required Qty: 1.00

D2989-5

Manufactured No

100

Each

6.0000

2

2



Rib



*SY 10/08/10*

Location

Loc Qty

Loc Code

ST

6

60555

2

60835

4

D3182-1

Manufactured No

100

Each

4.0000

2

2



Hinge



*SY 10/08/10*

Location

Loc Qty

Loc Code

WA

4

60176

4

D3442-3

Manufactured No

100

Each

8.0000

2

2



Shim



*SY 10/08/10*

Location

Loc Qty

Loc Code

WA

8

59290

2

60550

2

60837

4

D3827-041

Manufactured No

100

Each

9.0000

1

1



Rib Assembly (Inboard)



*SY 10/08/10*

Location

Loc Qty

Loc Code

ST

6

60445

6

WA

3

59982

3

*①*

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 60963



Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

Start Date: 7/30/2010

Required Date: 8/9/2010

Start Qty: 1.00

Required Qty: 1.00

D3832-5  
  
 Mesh (Lid)

Manufactured No 100 Each 3.0000 1 1



SAD 10-08-17

Location Loc Qty Loc Code

WA 3  
 60131 3

D3833-5  
  
 Mesh (Lid End)

Manufactured No 100 Each 11.0000 2 2



SAD 10-08-17

Location Loc Qty Loc Code

WA 11  
 53722 1  
 59412 4  
 60673 6

D3838-041  
  
 Rib Assembly (Basket Lid, LH)

Manufactured No 100 Each 2.0000 1 1



10/08/10

Location Loc Qty Loc Code

WA 2  
 60554 2

D3838-042  
  
 Rib Assembly (Basket Lid, RH)

Manufactured No 100 Each 2.0000 1 1



10/08/10

Location Loc Qty Loc Code

ST 2  
 60553 2  
 WA 2

Friday, July 30, 2010 8:23:14 AM

Shop Packet Print

Page 3

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**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED  
08/11/18

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 60963

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
  - 8) WELD PER DART QSI 004

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**Dart Aerospace Ltd**

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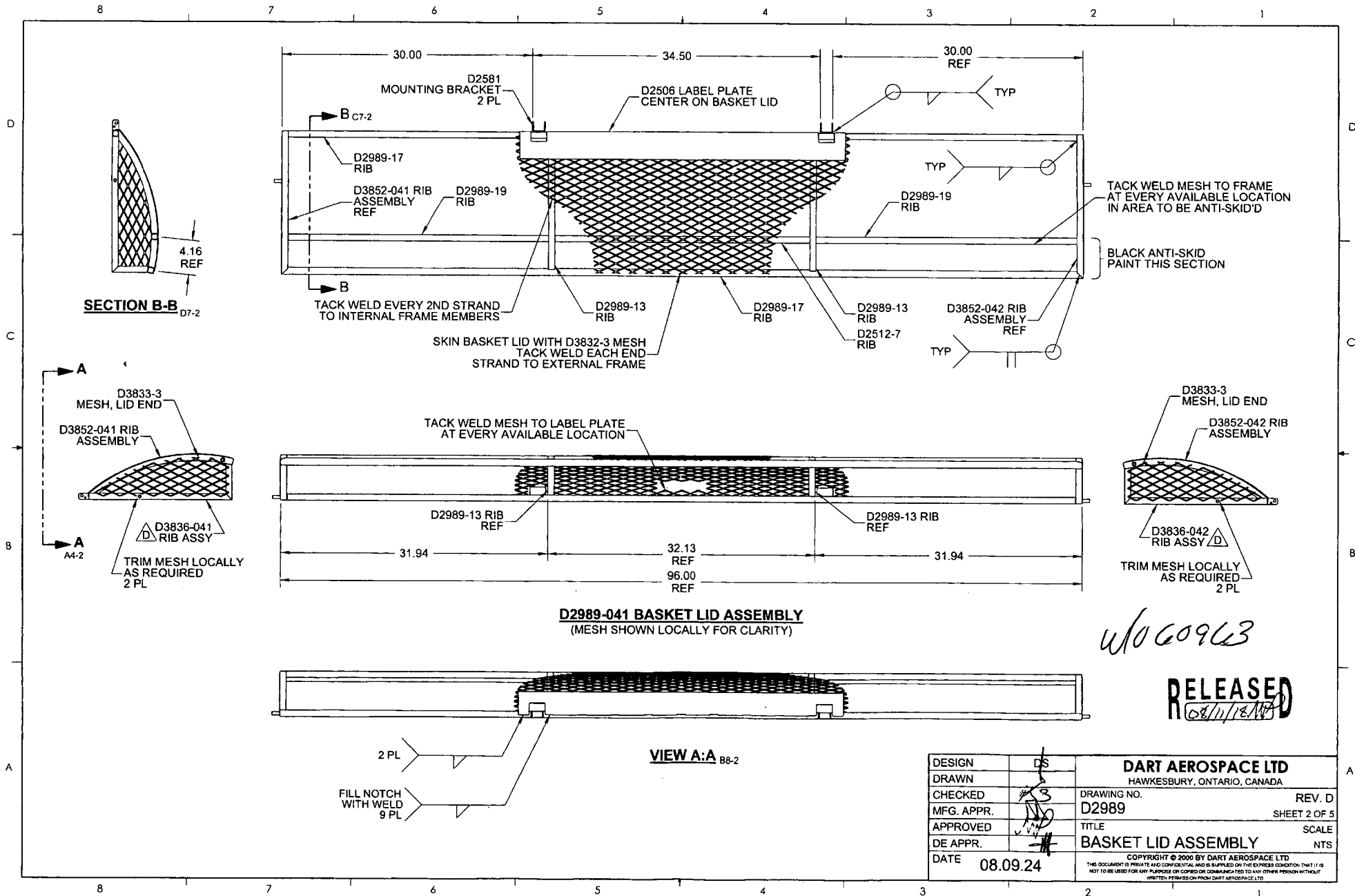
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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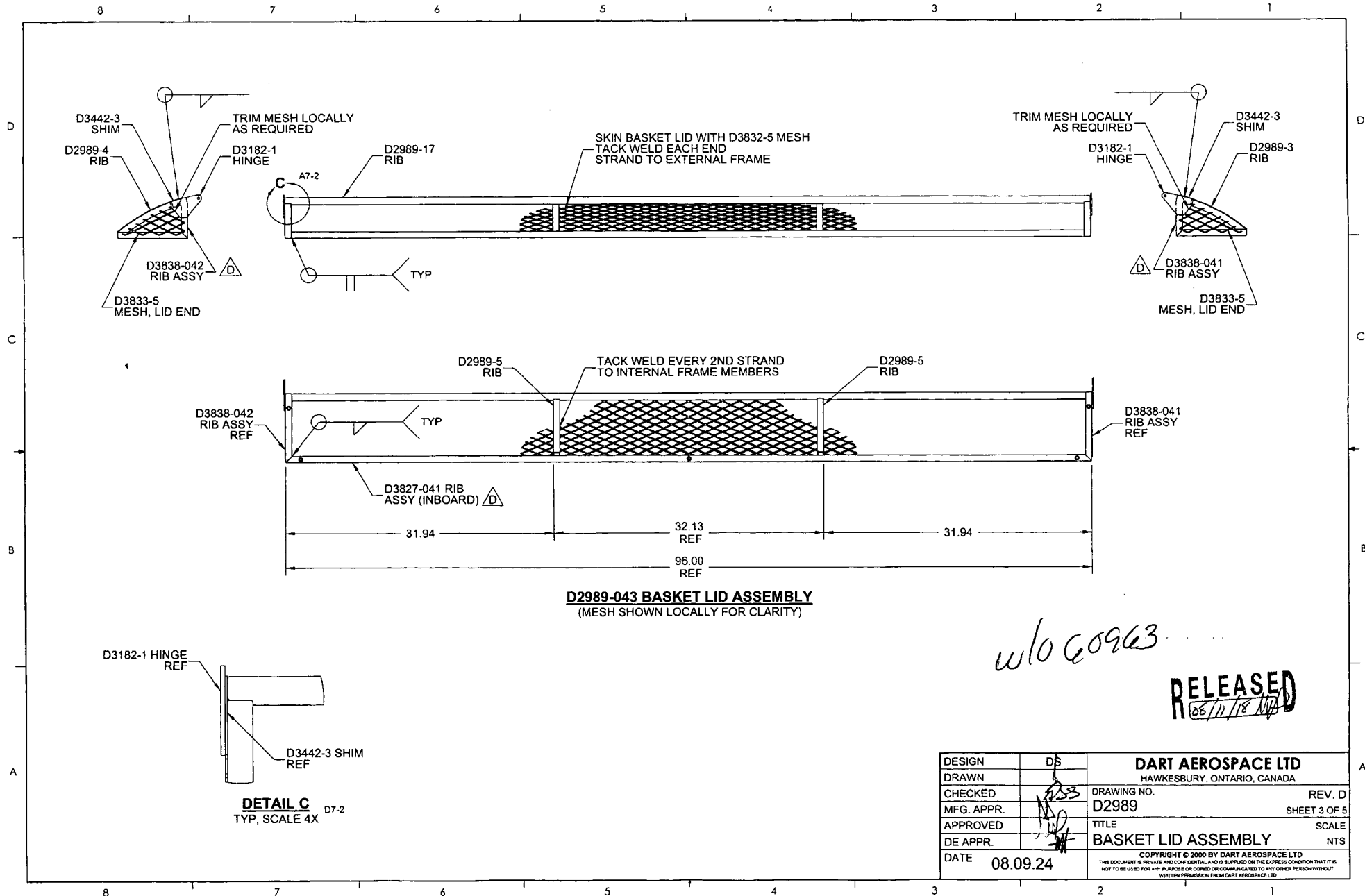
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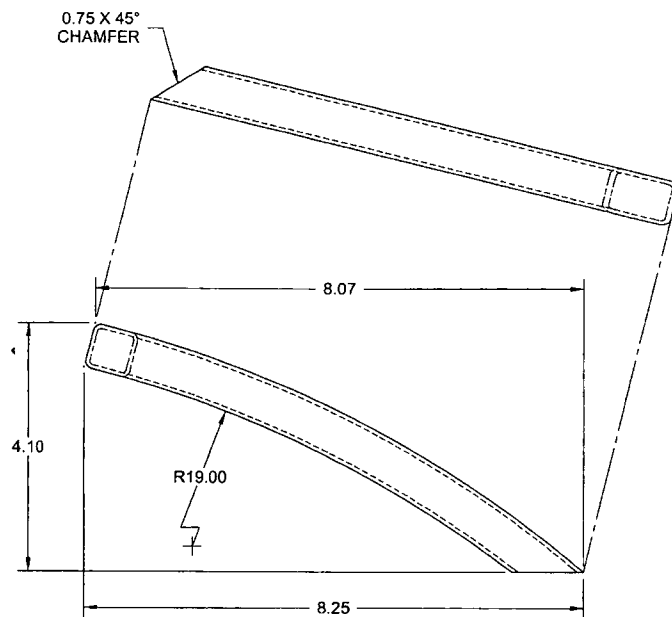
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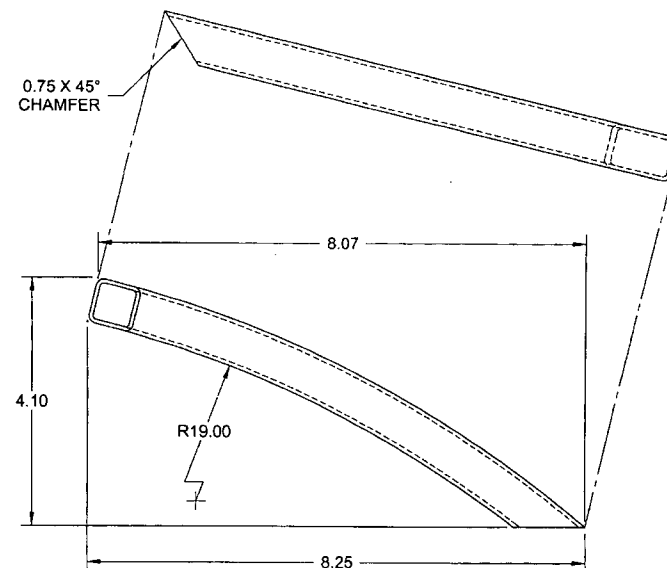
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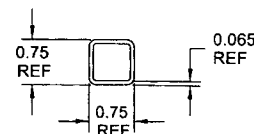
**D2989-3 RIB**



**D2989-4 RIB**

*w/o 40963*

**RELEASED**  
08/11/18



**TYPICAL SECTION VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D2989</b>	REV. D
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET LID ASSEMBLY</b>	NTS
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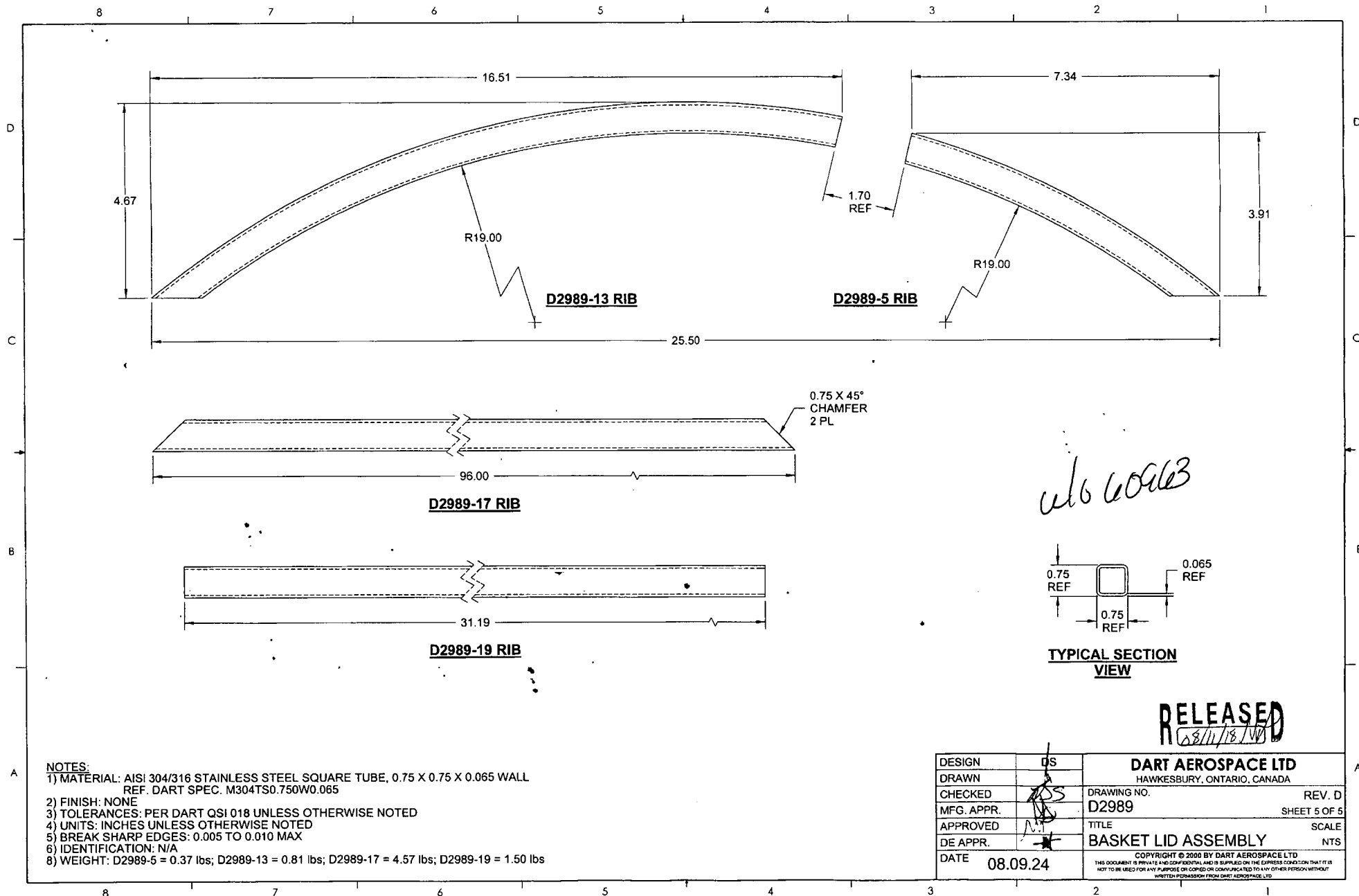
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**NOTE:** Date & initial all entries



DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	SS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SS	DRAWING NO.	REV. D
MFG. APPR.	SS	D2989	SHEET 5 OF 5
APPROVED	SS	TITLE	SCALE
DE APPR.	SS	BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries